

Work Order ID 59424

Friday, June 04, 2010 9:21:21 AM



Page 1

Item ID: D3490-1

Accept



Setup Start



Revision ID:

Item Name: Cross Bolt Spacer

Stop



Start Date: 6/4/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

PH

Date:

10/6/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3490

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA628 & DWG D3490 FOLIO
REV: *A* DWG REV: *A* 2-DEBURR AS REQUIRED

SA 10/06/07

43 *Ø*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 10/06/07

43 *Ø*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

AM 10/06/07

43 *Ø*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location <u>LG</u>	0.00							
Packaging	Memo	0.00				43	0	BE	10/06/09
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/06/09
MF 10-6-9

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NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 9:21:24 AM

Page 1

Work Order ID: 59424

Parent Item: D3490-1

Parent Item Name: Cross Bolt Spacer

Comments: IPP Rev:A New Issue 06-03-03 JLM

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.049		Purchased	No			100	f	109.8556	0.266	11.2			
6061-T6 RD Tube .500 x.049W													

Location

Loc Qty

Loc Code

MAT	28.2484	
114520	13.32	
114530	14.9284	
MAT014	81.6072	
111028	16.5895	
111944	5.0177	
114812	60	

11.6RT 5/10/07

1024

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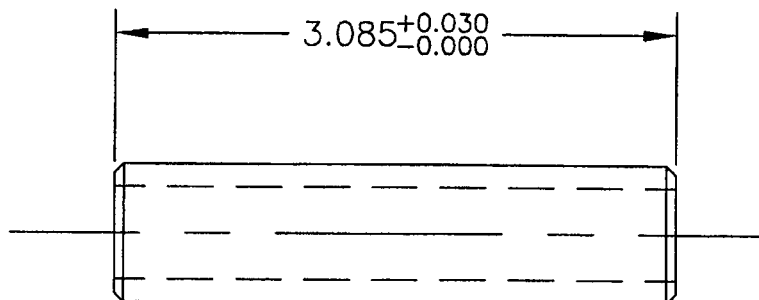
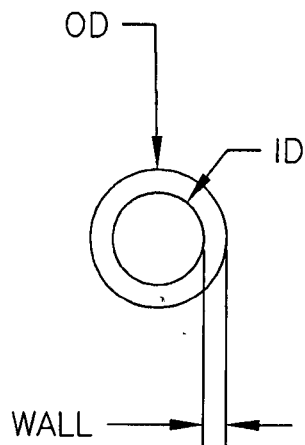
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DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. *59424*
BS10-6-04

0.050 X 45°
CHAMFER (TYP)

D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
06-02-07

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